

one way or another, and thus cause the bushings to stand at an angle with the work, producing faulty results. In order to avoid this objectionable feature, a further improvement on the jig, indicated in Fig. 9, is proposed. In the jig body, the locating points and the set-screws which hold the work against the locating pins are placed so that they will not interfere with two straps G, which are provided with elongated slots, and hold the work securely in place, also sustaining the thrust from the cutting tools. These straps should be heavily designed, in order to be able to take the thrust of the multiple-spindle drill, because in this case all the bushings, except the one for hole /*, are placed



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in the bottom of the jig
 body. The Uruf is madt*
 narrower and is not as
 heavy as the one shown in
 Fig. H, hmwst* it tlm*s not,
 in this case, take any thrust
 when drilling, ami simply
 serves the purpose of
 holding the bushing for holt*
H. Tltr leaves ami loose
 bushing plates for jigs of this
 kind art* gtwrally mittir of
 machine steel, but for
 larger sized jigs they may
 br made of i:ust Iron, The
 leaf in Fig. 9 is simply held
 down by the thumb-screw
IL

If the holeJ? comes near
 to ontr wall of ifir Jig, it
 may not
 be necessary to have a leaf,
 but the jig
 nwy tie with
 a projecting lug D, as shown
 in Fig, to, tlir jig
 luting
 of the same type as the one
 in «j, Titr
 projecting